

Date: Monday, 9/10/2007 4:05:53 PM
 User: Kim Johnston

Process Sheet

40

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L UTILITY BASKET
 Job Number : 34479
 Estimate Number : 11272
 P.O. Number : N/A Part Number : D206540011
 This Issue : 9/10/2007 S.O. No. : N/A Drawing Number : D206-540 REV I
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : 1
 Previous Run : 32976 Material : N/A
 Written By : Due Date : 9/30/2007 Qty: 1 Um: Each
 Checked & Approved By : Kim Johnston
 Comment : Est Rev I Revised per Rev I 05-12-06 JLM
 Est Rev:H 07-03-20 As per DS19361 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



u 07-09-28
CHG005



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-011 CHG004

u 07-09-28

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0 34479A 206L BASKET BASE - UNDER REVIEW



Comment: Sub-Component 206L BASKET BASE

D2252-041 B 34479A

SAN 07-09-27 (1)

4.0 34479B 206L BASKET LID - UNDER REVIEW



Comment: Sub-Component 206L BASKET LID

D2252-043 B 34479B

SAN 07-09-27 (1)

5.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 332572

GS
GS 07/09/25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B30543

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B32573

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B31486

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B32574

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4. D2931 Bumper B321139

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet 1104715

CP 14/09/250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt M102140-

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M101938-

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M104093-

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M102959-

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt M104885-

17.0

AN960JD416

Washer



Comment: Qty.: ~~2~~ 4.0000 Each(s)/Unit Total : ~~2~~ 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number


Description Batch

4 AN960JD416

Washer M104746-

CP 07/09/250

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prd Mgr	Approval QC Inspector
07.09.26	17.0	QTY. 2 AN960SD416 L ARE REQUIRED TO REPAIR QTY. 2 AN960SD416 TO INSTALL PROPERLY ^{Batch M105403} TWO D2332-041 PROP ASSY.	SAD	07.09.27	2	 07.09.26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104156-

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M104885-

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M104537 M103585

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104936-

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M104683-

23.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2258-170 PLACARD

B16266-

07/09/250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L5

Nut



CP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M104812

25.0

D27283

Dart Logo label large



CP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Dart Logo label large

Batch: *B22553*

CP 07/09/25

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

GAD 07-09-27 ①

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07-09-27 (x)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

29.0

D2249041

Fitting Assembly

En



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 d2249-041 bracket

B32609

CP

30.0

D33963

Inventory

En



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: *B32784*

CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259

Placard

B10671

32.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525

Spacer kit

B28554

33.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526

Bushing

B27555

34.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2537

BUSHING

B32574

35.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748

Clevis

B27560

36.0

D27495

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-5

Strut

B26887

B24137

37.0

D27497

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7

Strut

B24137

B26887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN4-21A Bolt

M11695

CU

39.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
8 AN4-5A Bolt

M120857

CU

40.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN4-12A Bolt

M105143

CU

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN5-17A Bolt

M104885

CU

42.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
12 AN960JD416 Washer

M104746

CU

43.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN960JD516 Washer

M104156

CU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/01/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 34479

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M104683

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5

Nut

M104812

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-011

Location:

PPP Rev:

H

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-19-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 1 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
6	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 34479AJ460JD416L
QTY=2

02.09.26



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-540	REV. 1 SHEET 2 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-540-011	70 lb	40.0 in	2800 in-lb	111.0 in	7770 in-lb
206 L Series Basket Installation	31.8 kg	1.0 m	31.8 m-kg	2.8 m	89.0 m-kg
D206-540-013	50 lb	40.0 in	2000 in-lb	99.0 in	4950 in-lb
206 A/B Series Basket Installation	22.7 kg	1.0 m	22.7 m-kg	2.5 m	56.8 m-kg

GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement MMS-D206-540.

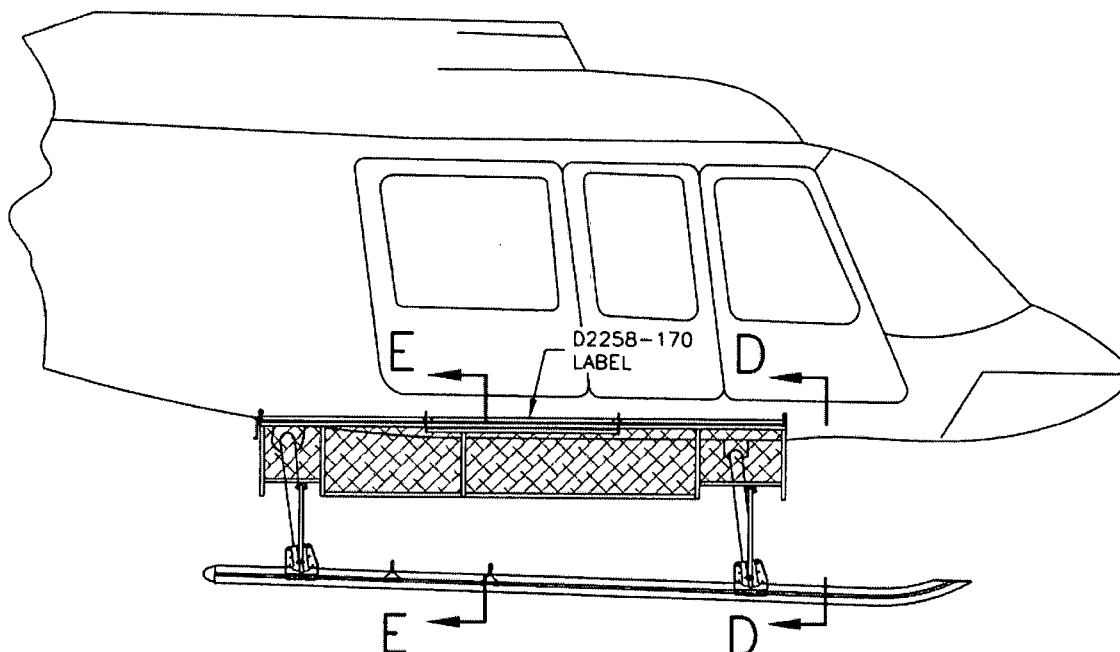
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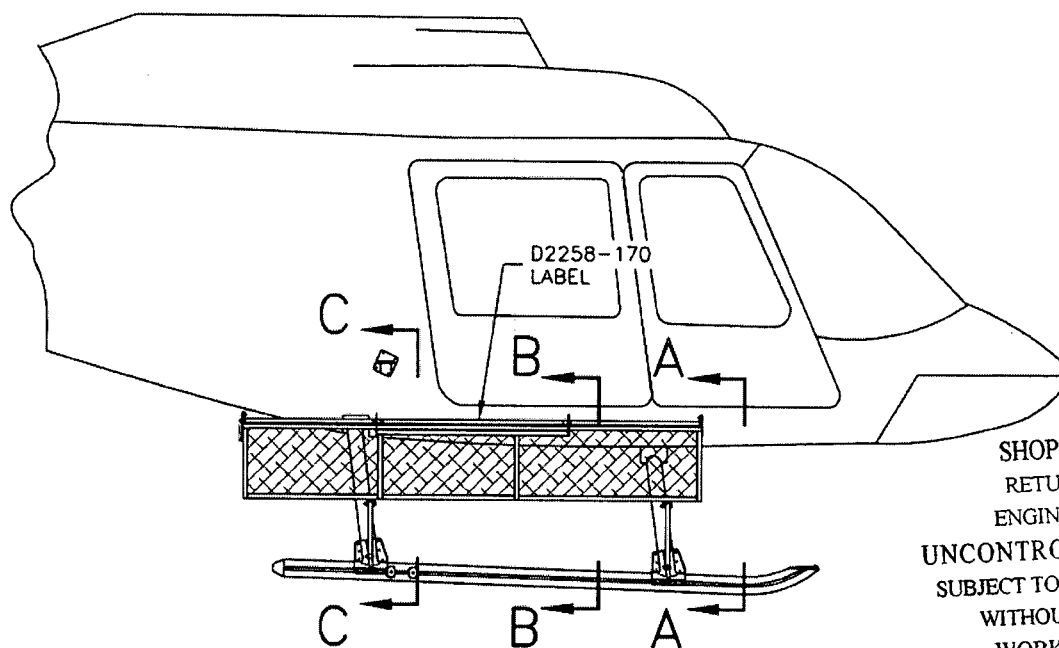
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CHECKED H	APPROVED H	DRAWING NO. D206-540	REV. 1 SHEET 3 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

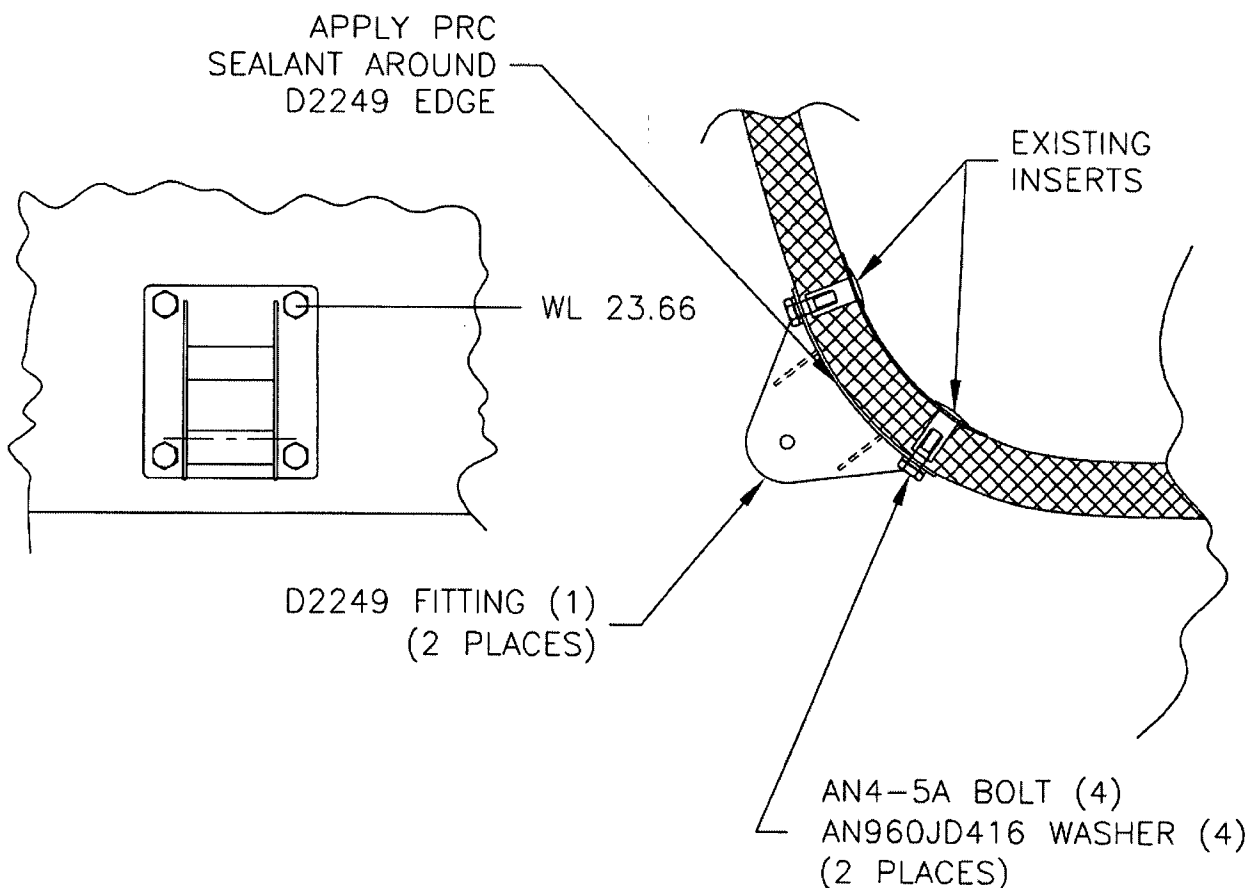
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DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS



BRACKET DETAIL
REPLACE 206-031-370-6
AND 206-031-370-8 STEPS AS
REQUIRED WITH D2249 FITTINGS.
REFER TO SERVICE INSTRUCTION
BHT-206-SI-22

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NO. 34479

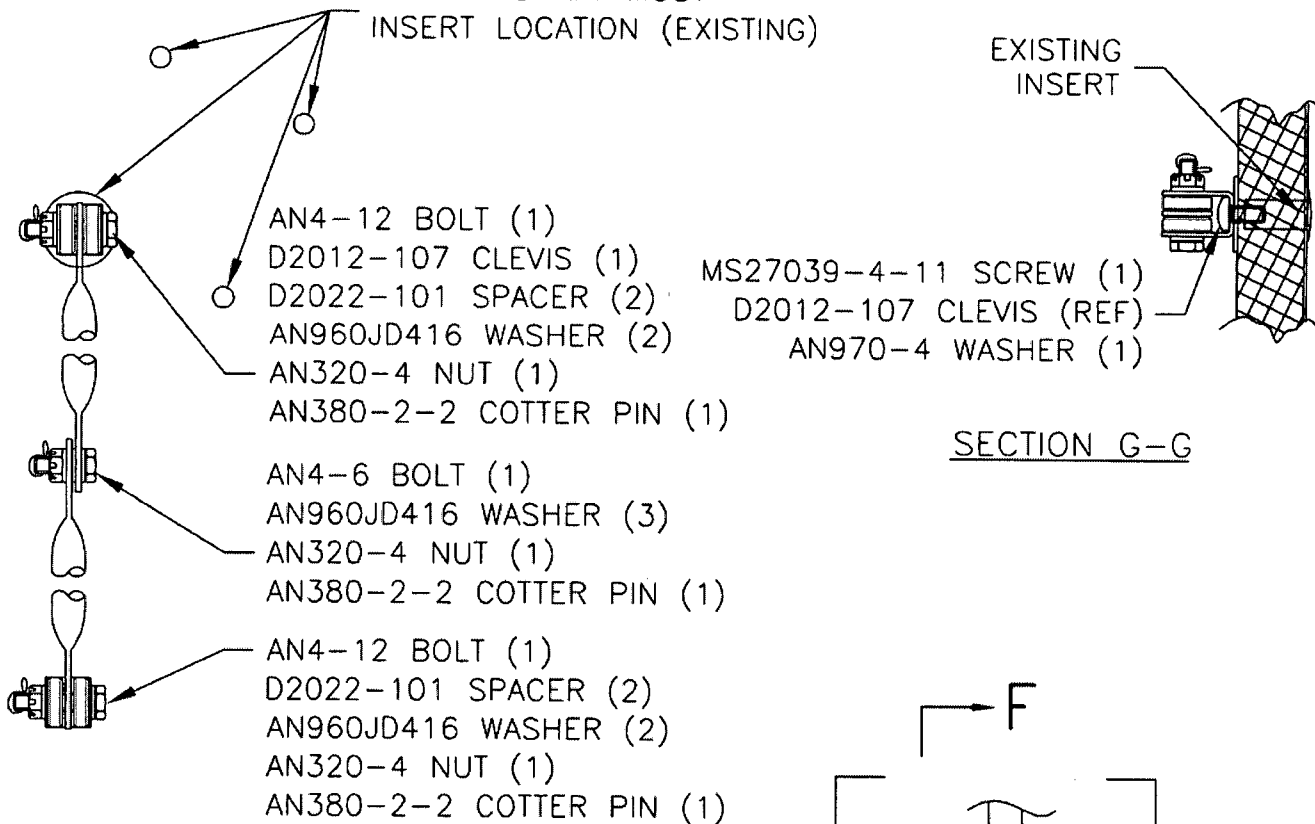
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DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

MOUNT TO AFT MOST
INSERT LOCATION (EXISTING)



*NOTE: DO NOT OVERTIGHTEN NUTS,
ALLOW STRUTS TO ROTATE

**NOTE: D2022-101 SPACERS CAN BE
REPOSITIONED TO LINE-UP STRUT

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NO. 34479

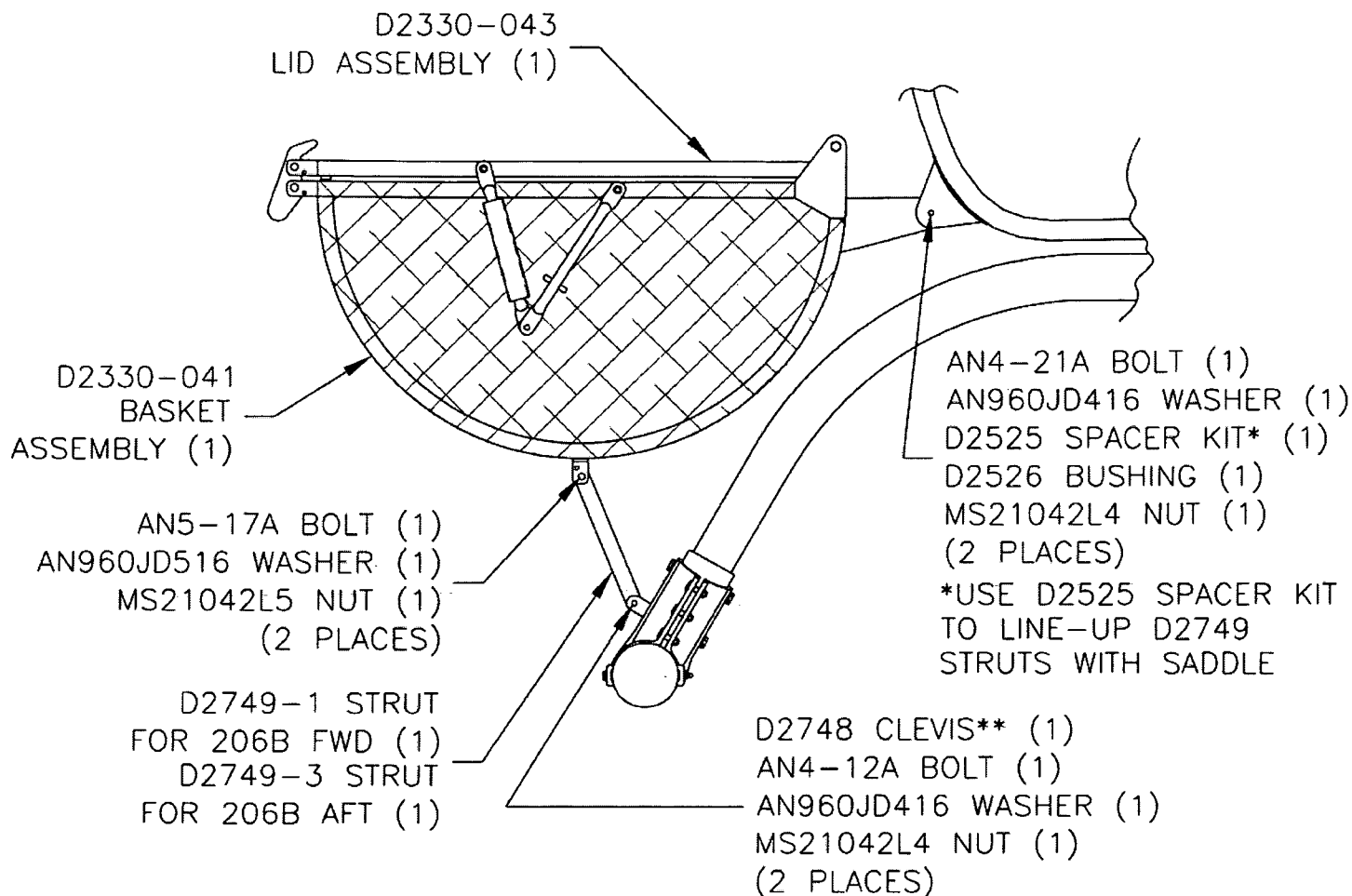
D206-540-013 (206 A/B) ONLY

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DATE	05.11.10	DRAWING NO.	D206-540	REV. 1
TITLE	UTILITY BASKET INSTALLATION	SHEET 6 OF 8	SCALE	





**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

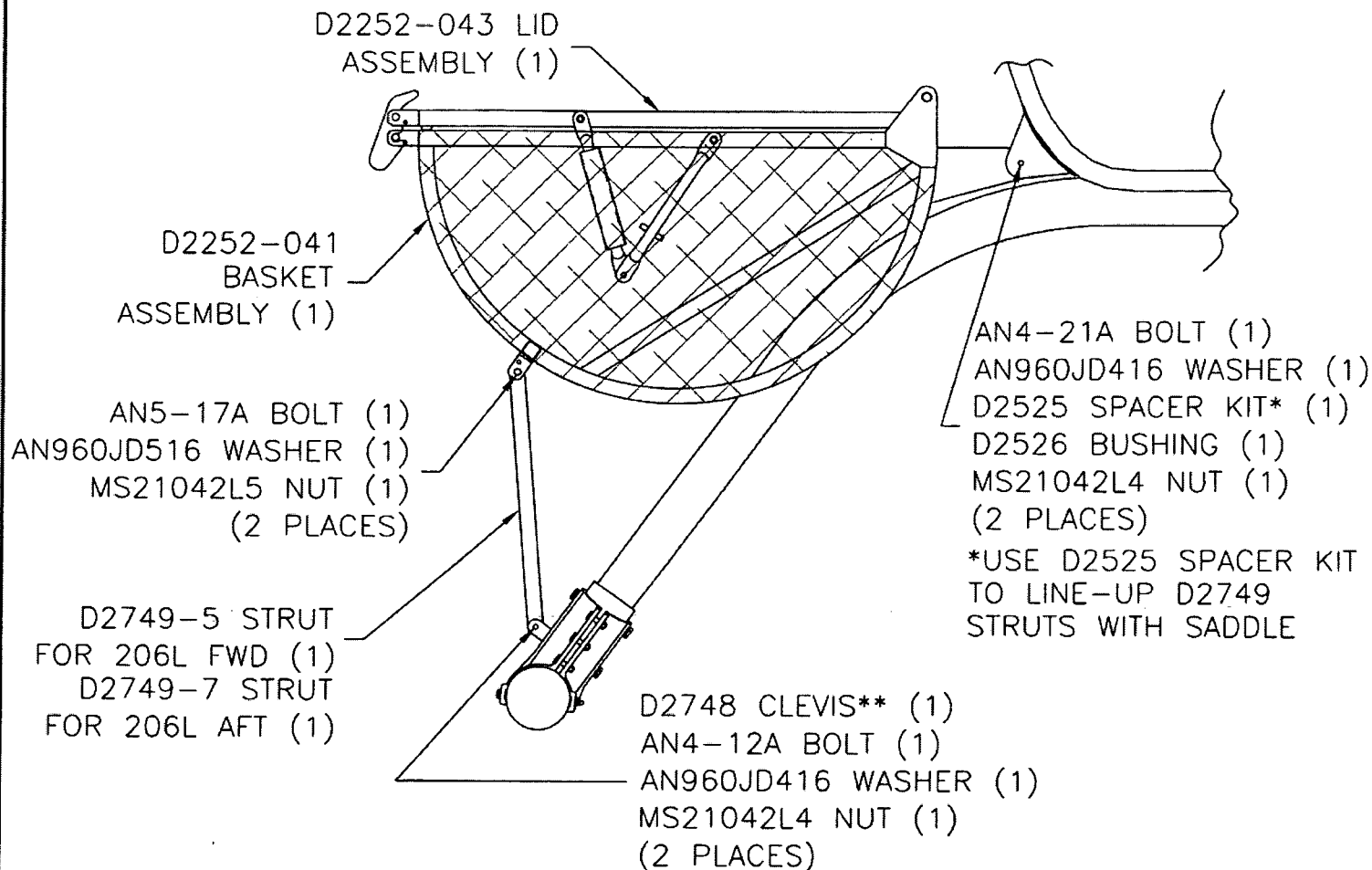
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		D206-540	SHEET 7 OF 8
DATE	TITLE		SCALE
05.11.10	UTILITY BASKET INSTALLATION		NTS



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

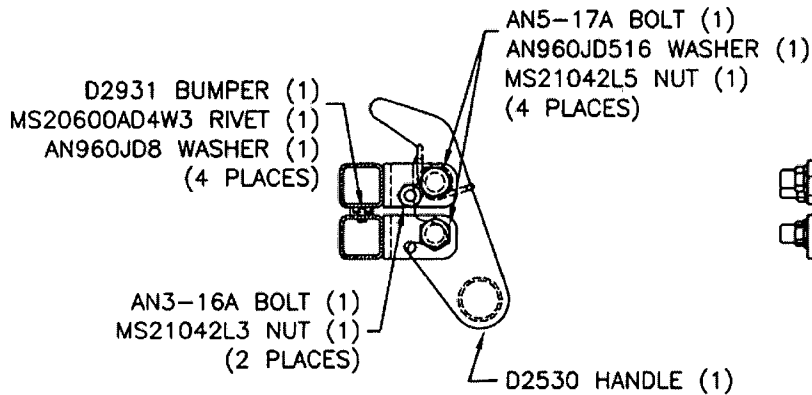
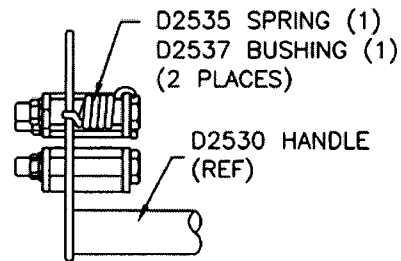
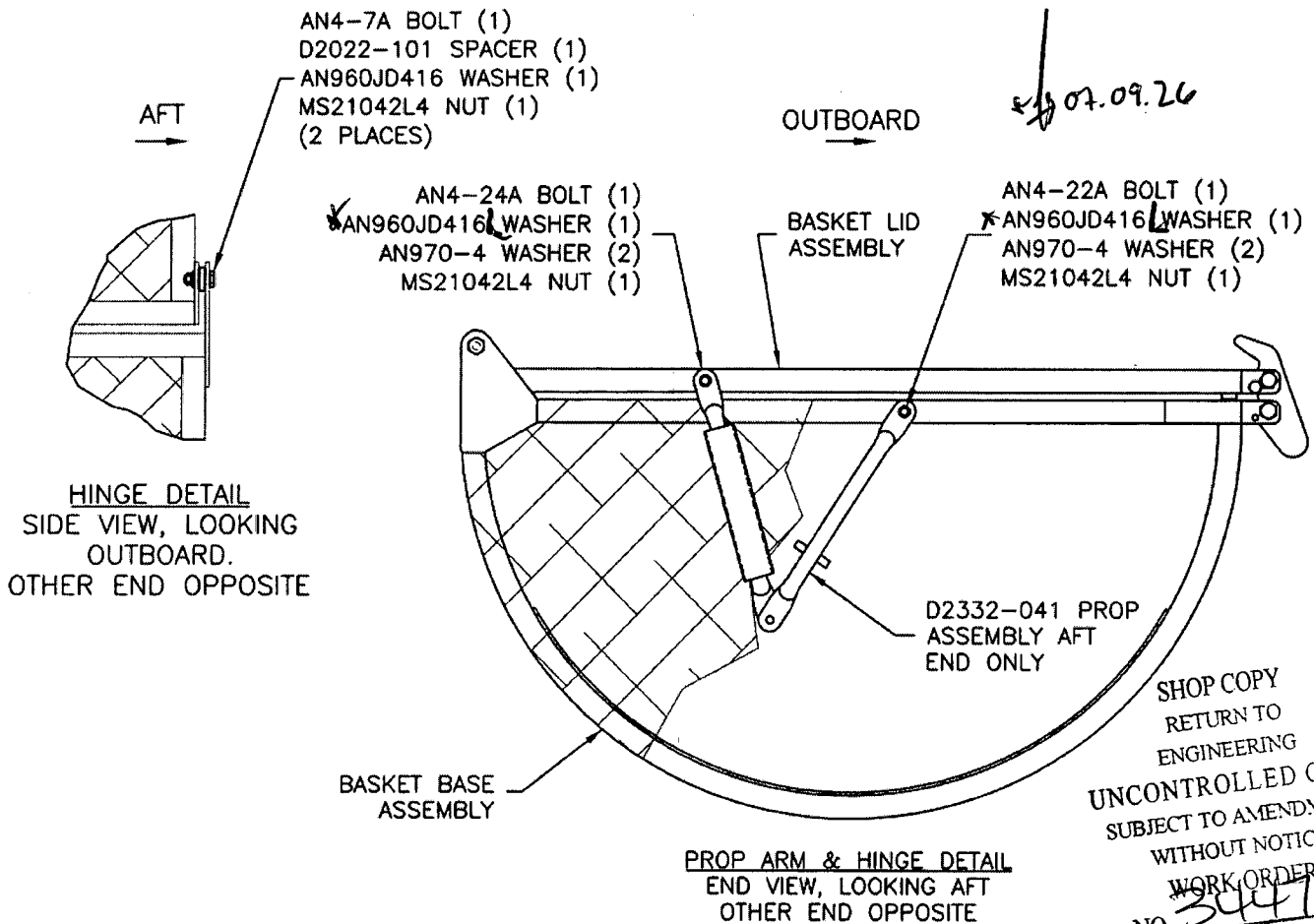
SECTION D-D AND E-E

D206-540-011 (206 L/L1/L3/L4) ONLY

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DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

LATCH DETAILSPRING DETAIL

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DATE 07.03.15		TITLE UTILITY BASKET SPACER	SCALE NTS
A	07.03.15	NEW ISSUE	

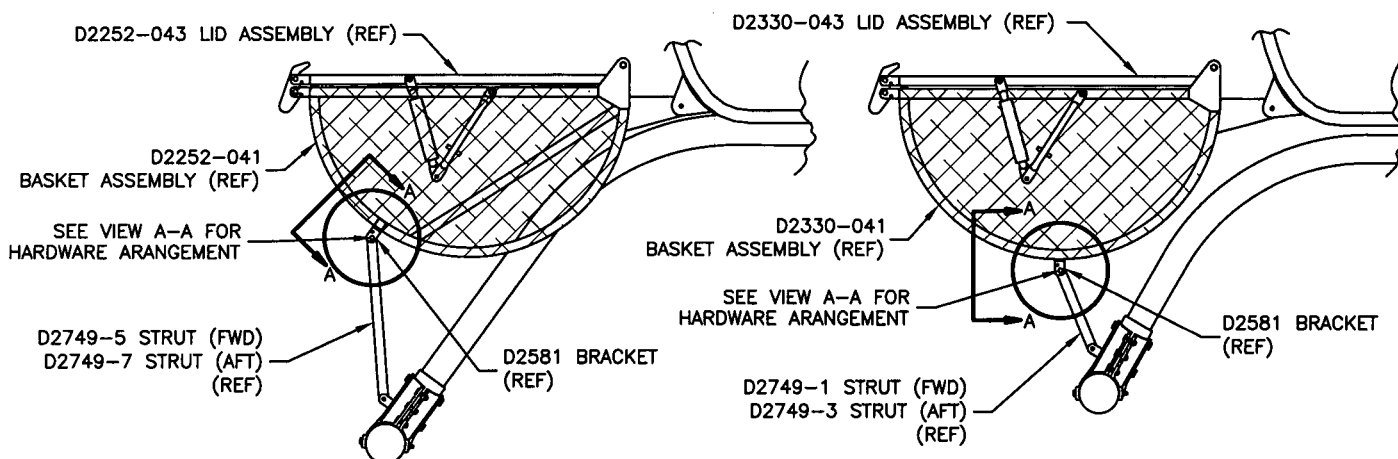
DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I
REF. CANADIAN STC: SH94-5
REF. FAA STC: SR00386NY

The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

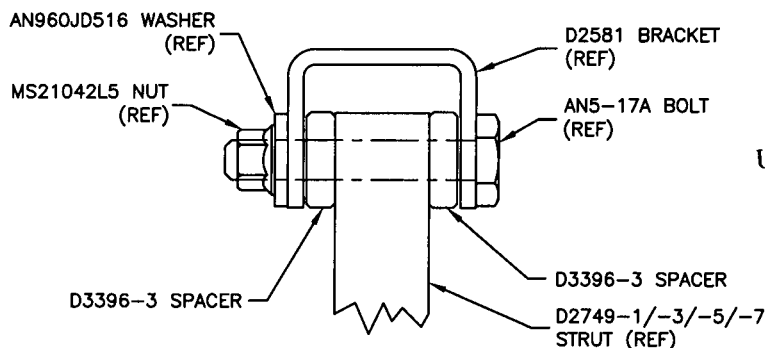
Qty - 011	Qty - 013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
4	4	D3396-3	SPACER

Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011
INSTALLATION**

**FIGURE 2 - D206-540-013
INSTALLATION**



**VIEW A-A - HARDWARE
ARRANGEMENT (TYP)**

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---	---

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Date: Monday, 9/10/2007 4:05:53 PM
 User: Kim Johnston

Process Sheet

*Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L UTILITY BASKET
Job Number	: 34479		
Estimate Number	: 11272		
P.O. Number	:	Part Number	: D206540011
This Issue	: 9/10/2007 S.O. No. :	Drawing Number	: D206-540 REV I
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: I
Previous Run	: 32976	Material	:
Written By	: <u>Johnston</u>	Due Date	: 9/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Johnston</u>		
Comment	: Est Rev: Revised per Rev I 05-12-06 JLM Est Rev: H 07-03-20 As per DSI9361 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-011 CHG004

07.09.12

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

REFERENCE ONLY

3.0	34479A	206L BASKET BASE - UNDER REVIEW
-----	--------	---------------------------------



Comment: Sub-Component 206L BASKET BASE

D2252-041 B

4.0	34479B	206L BASKET LID - UNDER REVIEW
-----	--------	--------------------------------



Comment: Sub-Component 206L BASKET LID

D2252-043 B

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y

Monday, 9/10/2007 1:23:59 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET BASE UNDER REVIEW
Job Number	: 34479A	Part Number	: D2252041
Estimate Number	: 11273	Drawing Number	: D2252 UNDER REVIEW 07.09.11
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/10/2007 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 9/30/2007 Qty: 1 Um: Each
Previous Run	: 32976A		
Written By	: [Signature]		
Checked & Approved By	: [Signature] 07.09.11		
Comment	: Est Rev I Revised as per Rev E 05-12-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
-----	-------	-------------	-------

5	D3166-1	Hoop	B34423
---	---------	------	--------

PD 07-09-21

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M105283

PD 07-09-21

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

PD 07-09-21

4.0	D22531	Lug
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2253	Gusset	B27553
---	-------	--------	--------

PD 07-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:23:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE - UNDER REVIEW

Job Number: 34479A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B33046

PD 07-09-21

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chanel B34445

PD 07-09-21

7.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

PD 07-09-21

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B31784

PD 07-09-21

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal M105497

PD 07-09-21

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: M105524

PD 07-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 7/10/28

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:23:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE - UNDER REVIEW

Job Number: 34479A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/21

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/21

13.0

POWDER COATING

POWDER COATING



M105068



(1x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/09/25

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-09-25

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

IP 37475 E-1/1/28 0

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/28 (1)

Job Completion



U 07-09-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

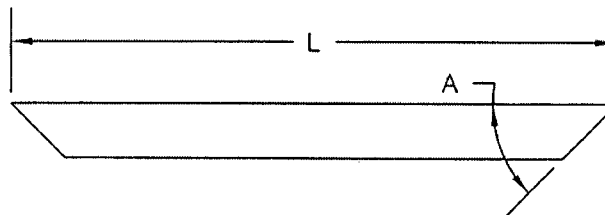
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) SCALE NTS	
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
		D2232-3	HINGE		
		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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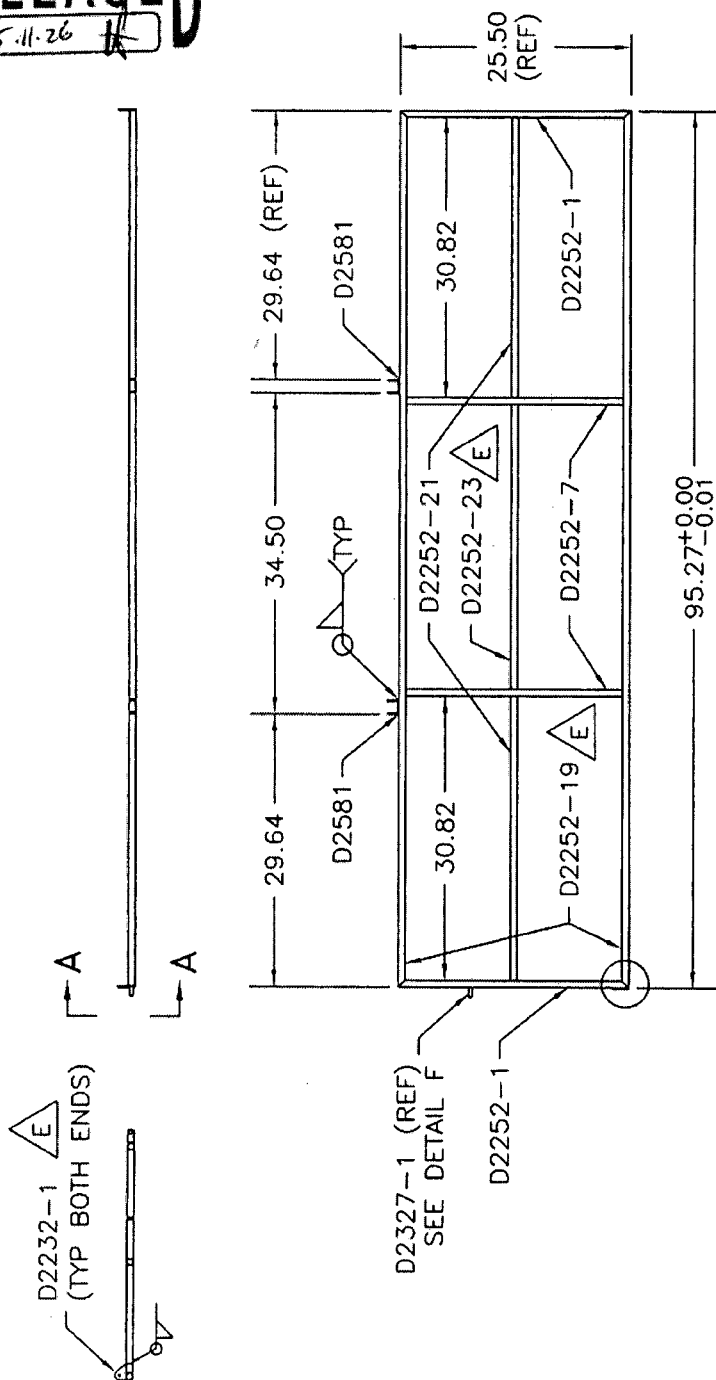
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS

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05.11.26



D2252-043 LID FRAME



WELD ALL JOINTS
AS SHOWN

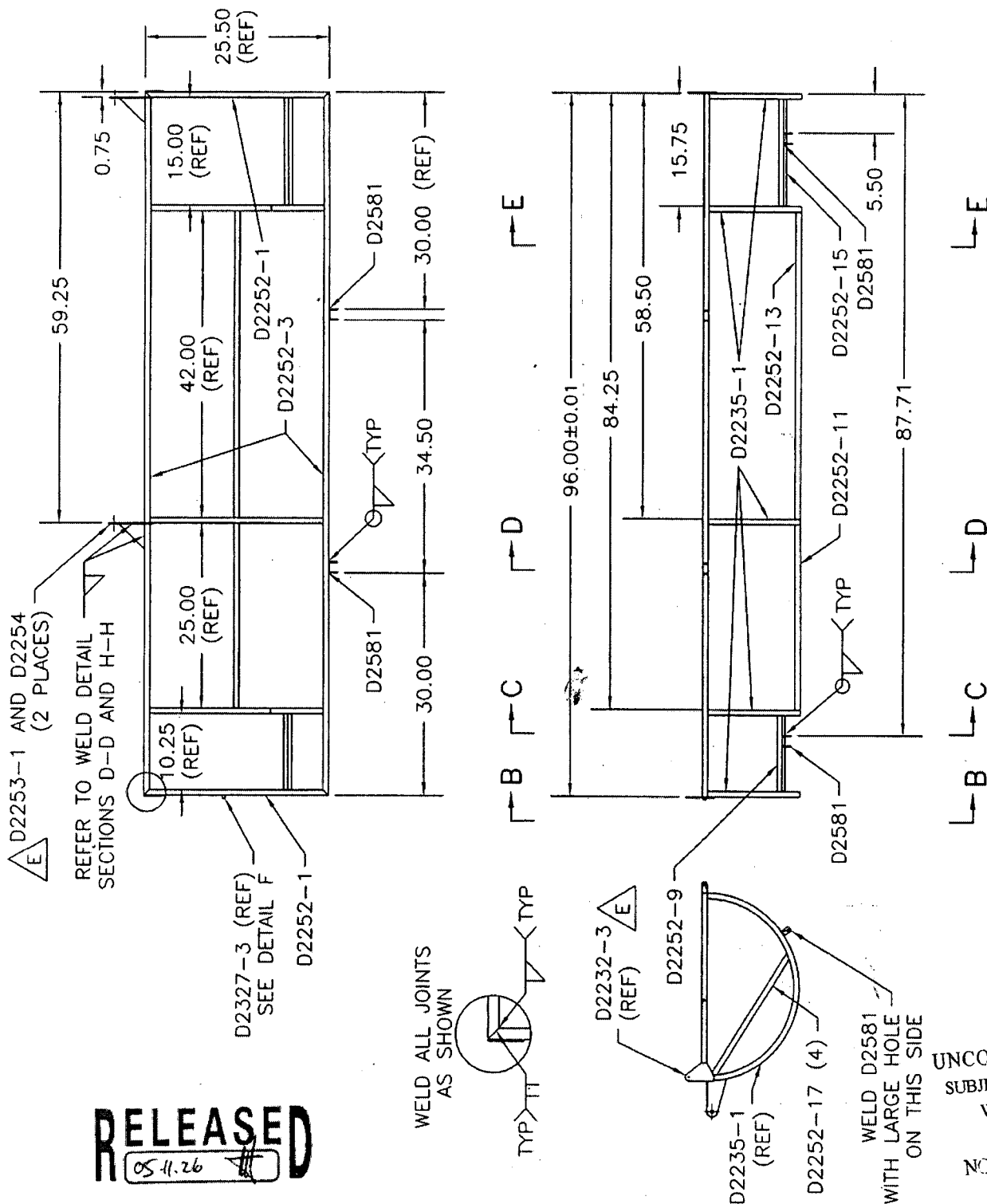
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS



D2252-041 BASKET FRAME

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05.11.26

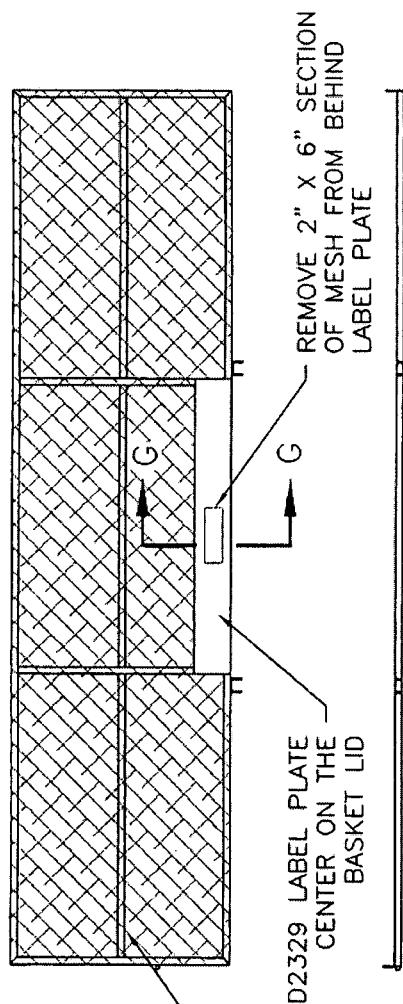
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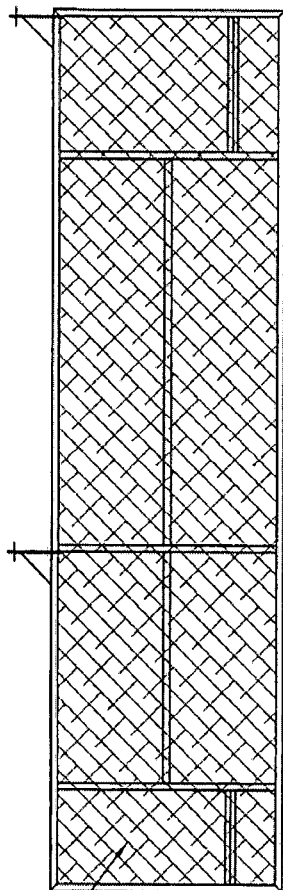
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS

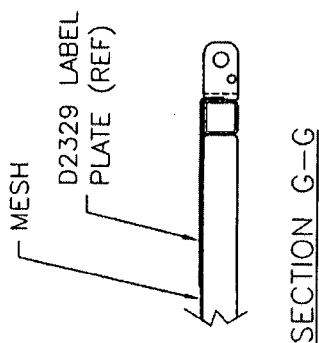


D2252-043 LID ASSEMBLY

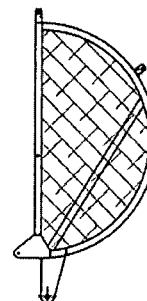


D2252-041 BASKET ASSEMBLY

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05.11.26



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME



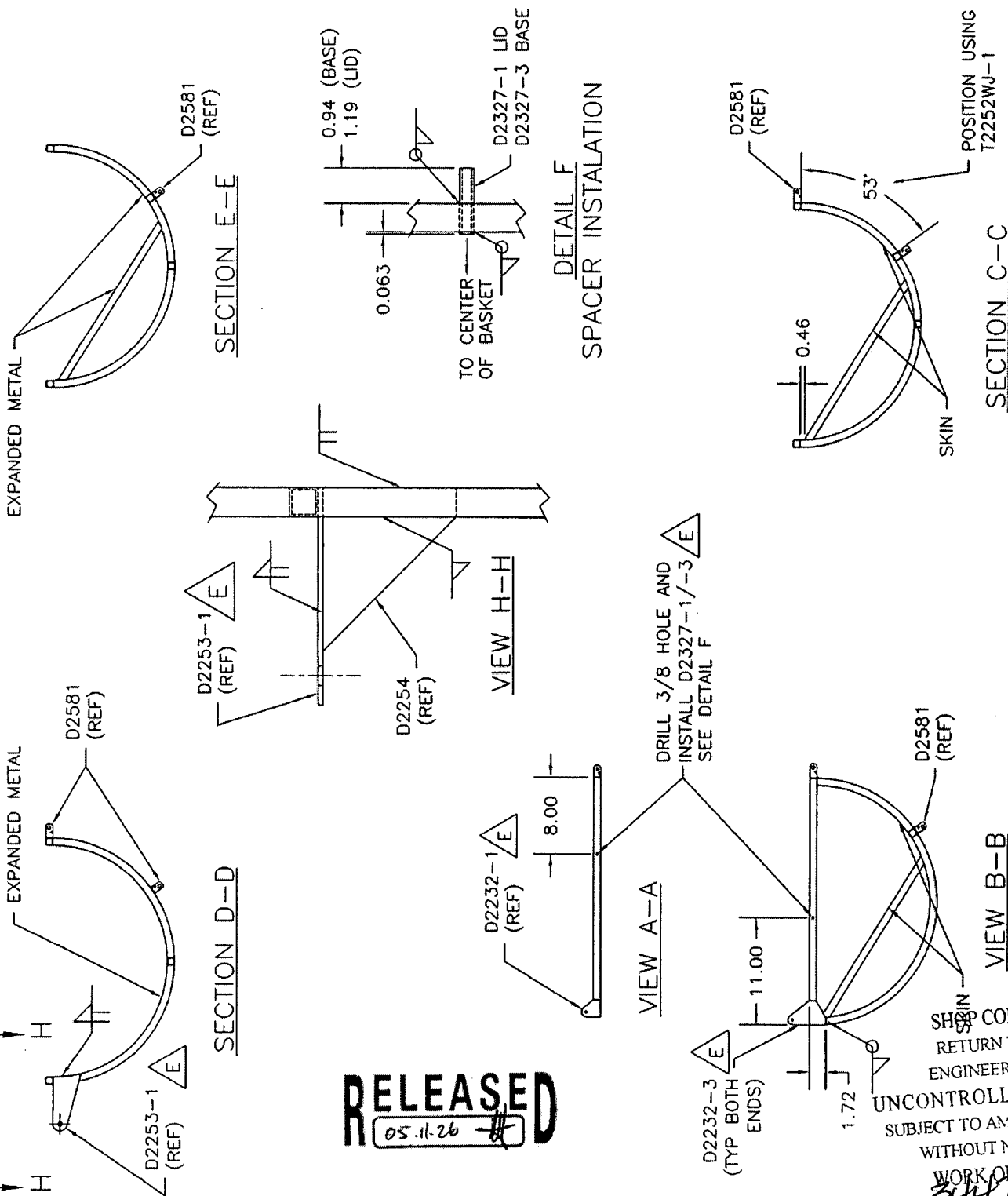
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS



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05.11.26

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Date: Monday, 9/10/2007 1:24:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET LID - UNDER REVIEW
Job Number : 34479B	
Estimate Number : 11274	
P.O. Number : N/A	Part Number : D2252043
This Issue : 9/10/2007 S.O. No. : N/A	Drawing Number : D2252 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 32976B	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 1 Um: Each
Comment : Est Rev. REVISED AS PER REV E 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M105283

PD

07-09-21

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

PD

07-09-21

3.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2329 Label Plate

B29936

PD

07-09-21

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2327-1 Bushing

B31693

PD

07-09-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:24:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID - UNDER REVIEW

Job Number: 34479B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B31608

PD 07-09-21

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

B34445

PD 07-09-21

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M105497

PD 07-09-21

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M10524

PD 07-09-21

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/21

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/21

11.0

POWDER COATING

POWDER COATING



M105068



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L 07/09/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 21/09/28

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:24:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID - UNDER REVIEW

Job Number: 34479B

Part Number: D2252043

• Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-09-25

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1PP 34479B 1 B

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
DOT/09/28

Job Completion



W 07-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



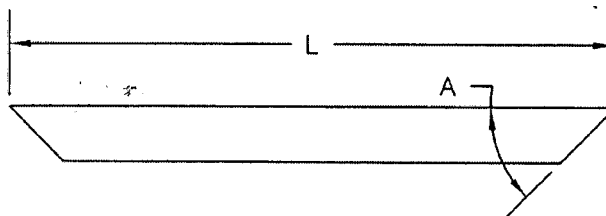
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) SCALE NTS	
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	26.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	13.00	90
4		D2252-17	FRAME	19.70	53
	2	D2252-19	FRAME	25.27	45
	2	D2252-21	FRAME	30.02	90
	1	D2252-23	FRAME	30.02	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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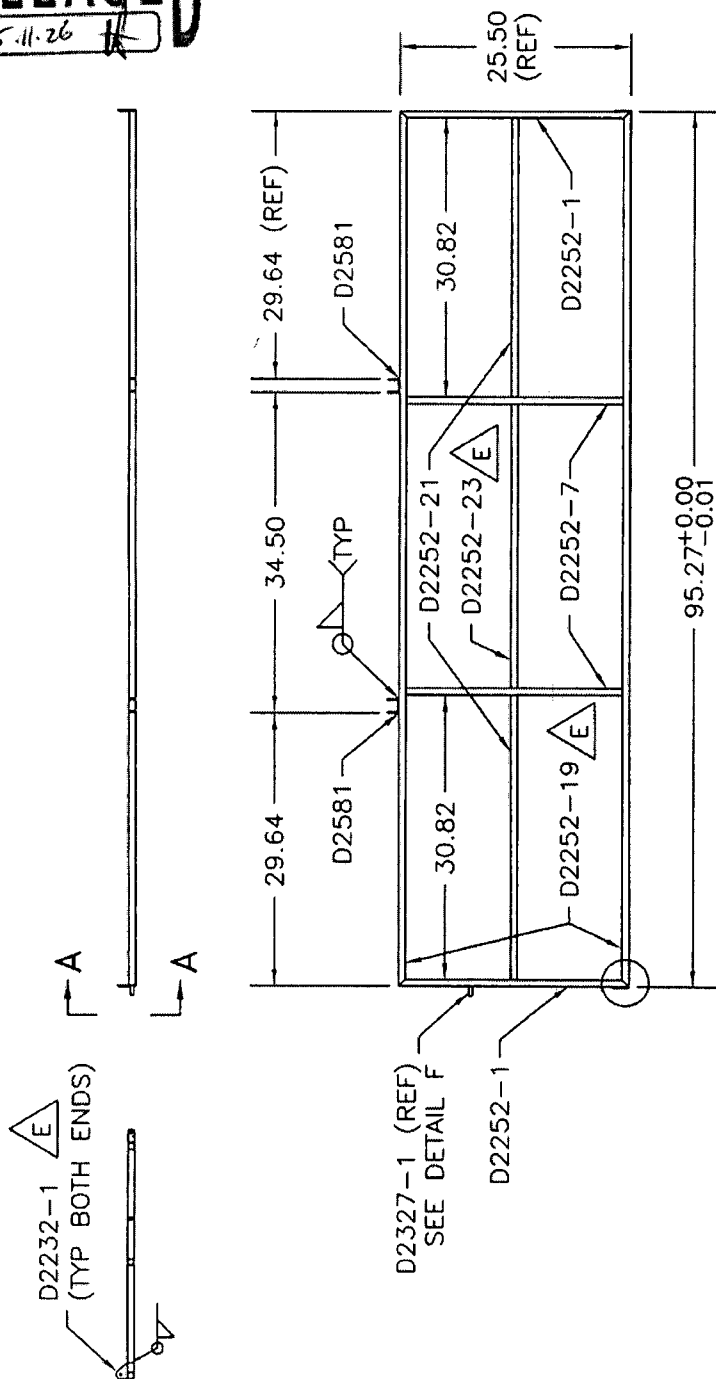
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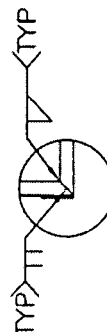


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D2252-043 LID FRAME



WELD ALL JOINTS
AS SHOWN

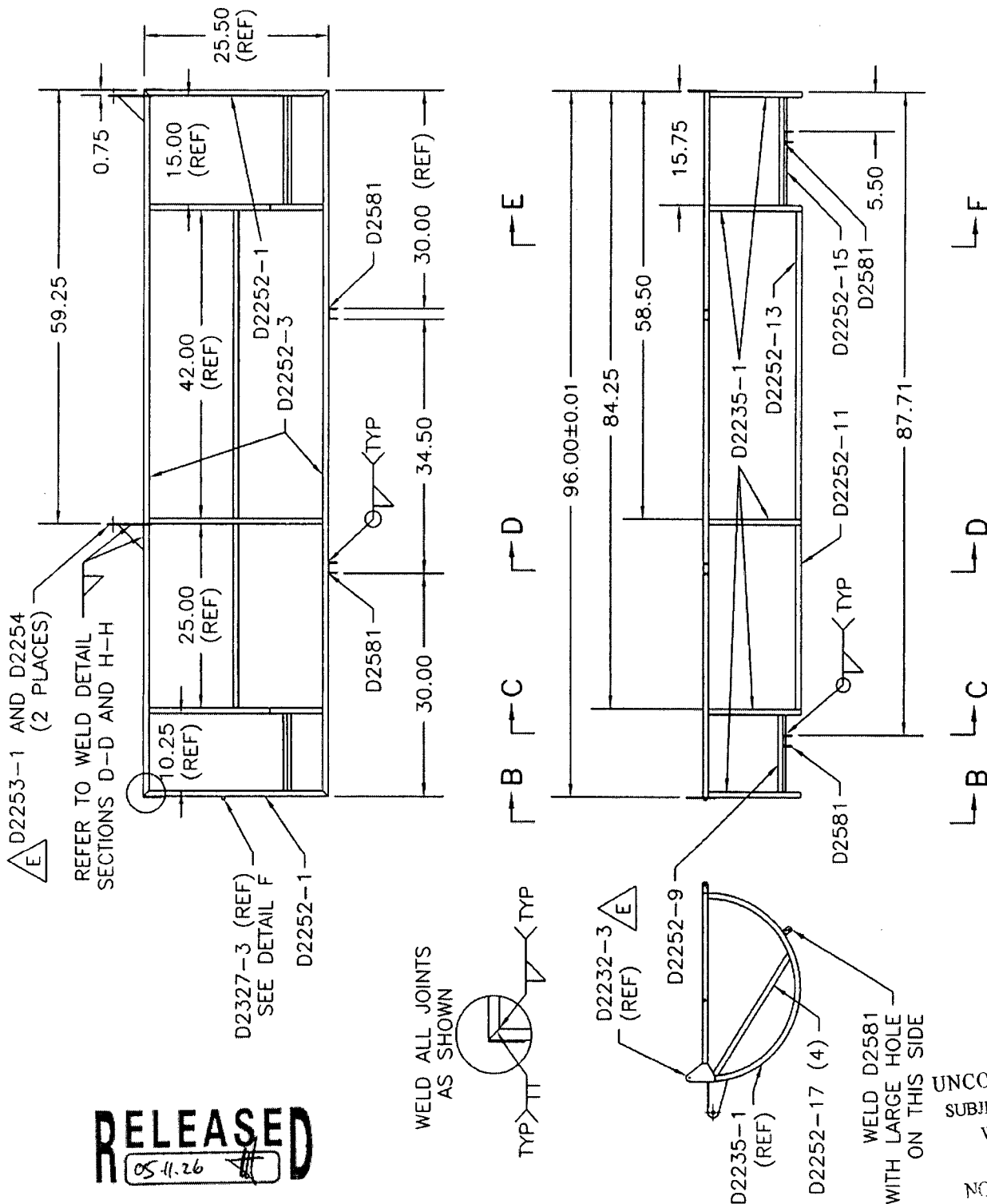
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS



D2252-041 BASKET FRAME

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05.11.26

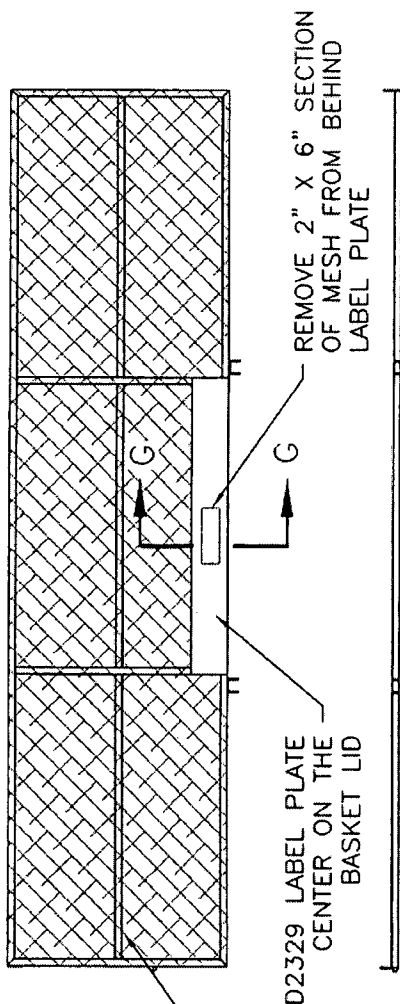
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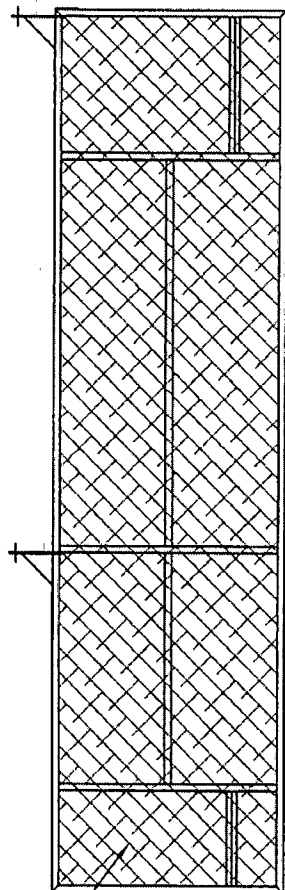
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				SCALE
				NTS

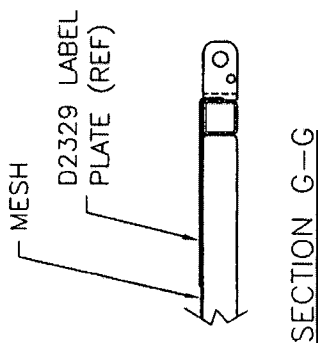


D2252-043 LID ASSEMBLY

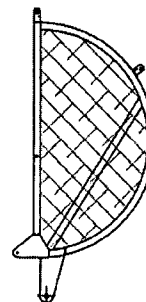


D2252-041 BASKET ASSEMBLY

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SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME



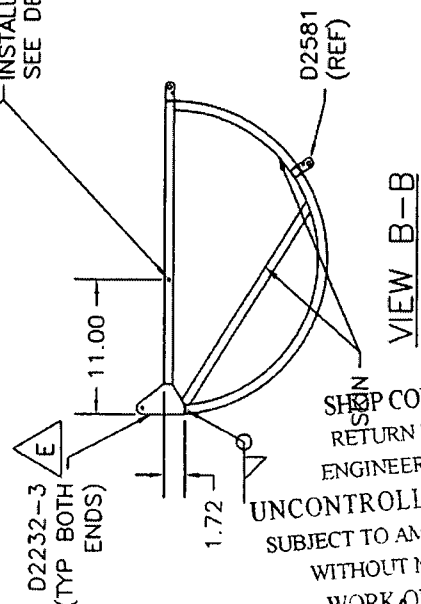
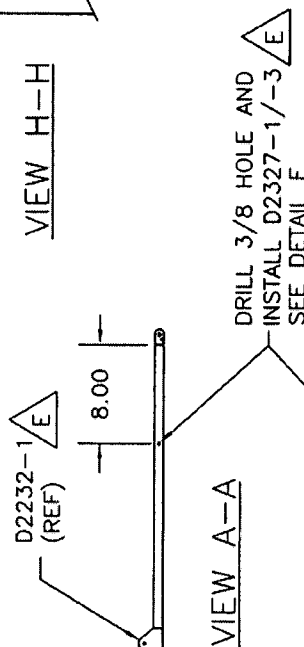
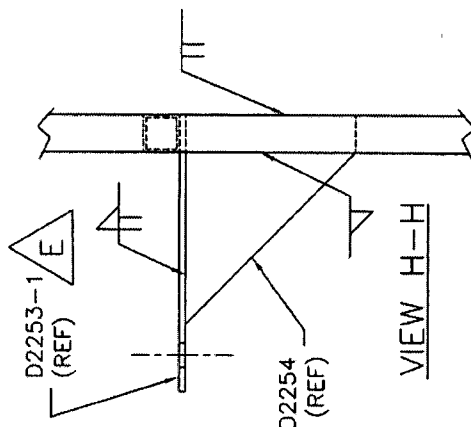
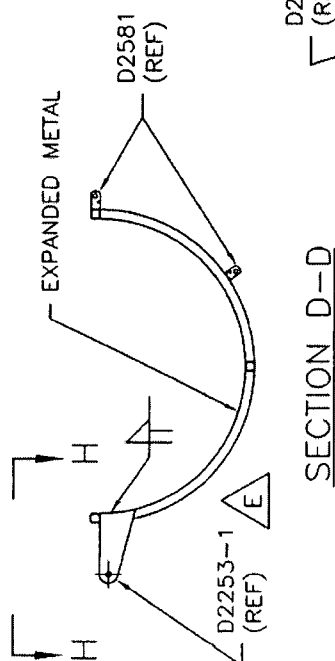
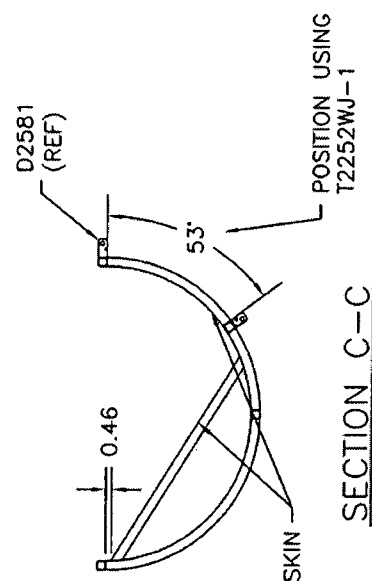
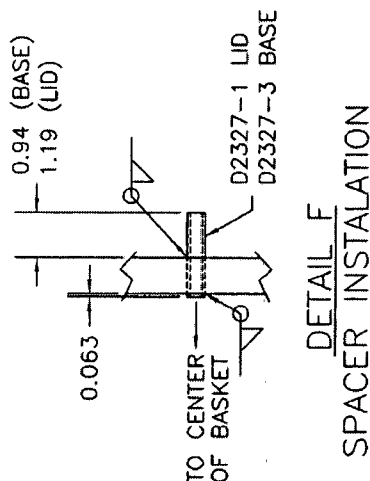
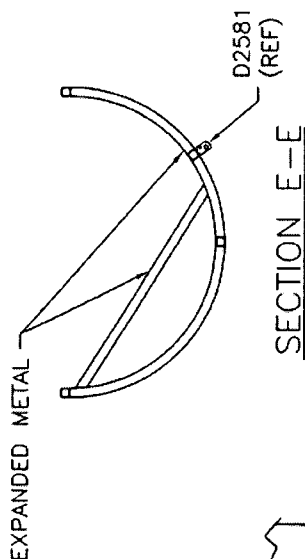
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